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IS 7267 (1991): Test chart for woodworking surface planing machines with cutterblock for one-side dressing [PGD 3: Machine Tools]



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“Knowledge is such a treasure which cannot be stolen”

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Indian Standard

**TEST CHART FOR WOODWORKING SURFACE
PLANING MACHINES WITH CUTTERBLOCK
FOR ONE-SIDE DRESSING**

(First Revision)

UDC 674.056 : 621.912.25 : 620.1 (084.3)

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BUREAU OF INDIAN STANDARDS
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Indian Standard

**TEST CHART FOR WOODWORKING SURFACE
PLANING MACHINES WITH CUTTERBLOCK
FOR ONE-SIDE DRESSING**

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NATIONAL FOREWORD

This Indian Standard (First Revision) which is identical with ISO 7571 : 1986 'Woodworking machines — Surface planing machines with cutterblock for one-side dressing' — Nomenclature and acceptance conditions' issued by the International Organization for Standardization (ISO), was adopted by the Bureau of Indian Standards on the recommendations of Woodworking Machines Sectional Committee (PE 01) and approval of Production Engineering Division Council.

This standard was first issued in 1974. Consequent upon the publication of ISO 7571 : 1986, this standard has been revised by adopting ISO 7571 : 1986 to bring it in line with ISO standard. In this revision, clause references of ISO 230 - 1 : 1986 for method of tests has been incorporated which were not there earlier.

The text of ISO standard has been approved as suitable for publication as Indian Standard without deviations. Certain conventions are however not identical to those used in Indian Standards. Attention is particularly drawn to the following:

- a) Wherever the words 'International Standard' appear, referring to this standard, they should be read as 'Indian Standard'.
- b) Comma (,) has been used as a decimal marker in ISO Standard while in Indian Standards, the current practice is to use point (.) as the decimal marker.

In this adopted standard, reference appears to certain International Standards for which Indian Standards also exist. The corresponding Indian Standards which are to be substituted in their place are listed below along with their degree of equivalence for the editions indicated:

<i>International Standard</i>	<i>Corresponding Indian Standard</i>	<i>Degree of Equivalence</i>
ISO/R 230 Test code for machine tools (since revised as ISO 230 - 1 : 1986)	IS 2063 : 1988 Code for testing machine tools (<i>first revision</i>)	Identical
ISO 7984 : 1988 Woodworking machines — Technical classification of woodworking and auxiliary machines (<i>see Note</i>)	NIL	—

NOTE — The technical committee responsible for the preparation of this standard has decided that the provisions of this ISO standard, is acceptable for use in conjunction with this standard.

Only the English language text of the International Standard has been retained while adopting it as Indian Standard

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Woodworking machines — Surface planing machines with cutterblock for one-side dressing — Nomenclature and acceptance conditions

1 Scope and field of application

This International Standard specifies the appropriate terminology for each part of the machine and, with reference to ISO 230/1, the geometrical tests for surface planing machines with cutterblock for one-side dressing; it also gives the corresponding permissible deviations which apply to machines of general purpose use and normal accuracy.

NOTE In addition to terms used in two of the three official ISO languages (English and French), this International Standard gives the equivalent terms in German, Spanish, Italian and Swedish in an annex; these have been included at the request of Technical Committee ISO/TC 39 and are published under the responsibility of the member bodies for Germany, F.R. (DIN), Spain (IRANOR), Italy (UNI) and Sweden (SIS). However, only the terms given in the official languages can be considered as ISO terms.

This International Standard deals only with the verification of accuracy of the machine. It does not apply to testing the running of the machine (vibrations, abnormal noises, stick-slip motion of the components, etc.), nor to its characteristics (speeds, feeds, etc.) which should generally be checked before testing accuracy.

This International Standard does not impose any practical test for surface planing machines with cutterblock for one-side dressing. Practical tests should be exceptions and have to be stated in a previous agreement between the manufacturer and the user.

This International Standard applies to those machines designated by the number 12.211.1 in ISO 7984.

2 References

ISO 230/1, *Acceptance code for machine tools — Part 1: Geometric accuracy of the machine operating under no load or finishing conditions.*

ISO 7984, *Woodworking machines — Technical classification of woodworking and auxiliary machines.*¹⁾

3 Preliminary remarks

3.1 In this International Standard all dimensions and permissible deviations are expressed in millimetres.

3.2 To apply this International Standard, reference should be made to ISO 230/1, especially for installation of the machine before testing, the warming up of the cutterblock and other moving parts, and description of measuring methods. The measuring instruments shall not permit errors over 1/3 of the tolerances being checked.

3.3 The sequence in which the geometrical tests are given is related to the sub-assemblies of the machine and this in no way defines the practical order of testing. In order to make the mounting of instruments or gauging easier, tests may be applied in any order.

3.4 It is not always possible nor necessary to carry out all the tests given in this International Standard.

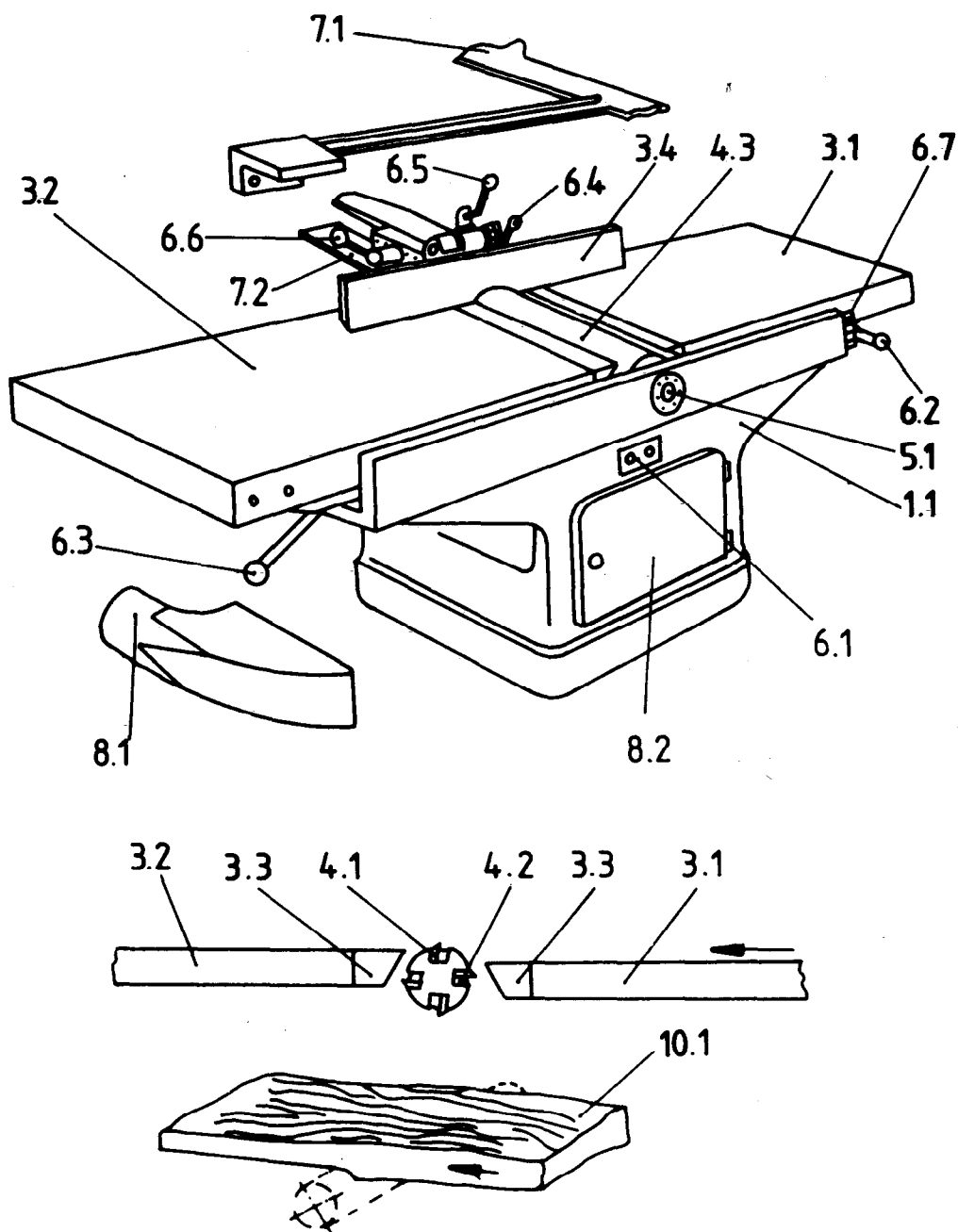
3.5 It is up to the user to choose, in agreement with the manufacturer, those tests relating to the properties which are of interest to him, but these tests shall be clearly stated when ordering a machine.

3.6 A movement is longitudinal when it takes place in the working direction of the piece.

3.7 When establishing the tolerance for a measuring range different from that given in this International Standard (see clause 2.311 in ISO 230/1), it should be taken into consideration that the minimum value of the tolerance is 0,01 mm.

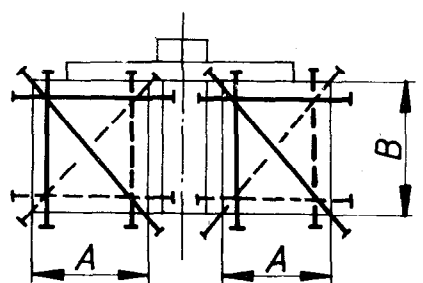
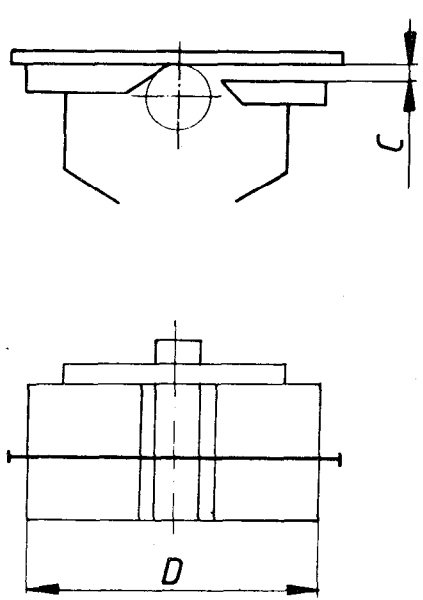
1) At present at the stage of draft.

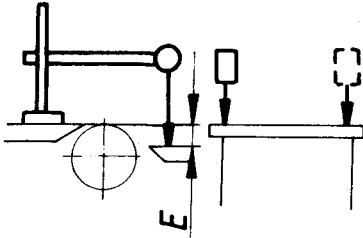
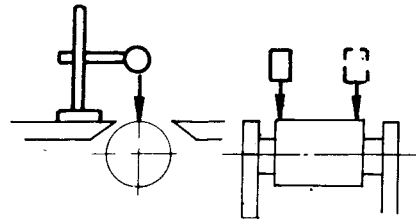
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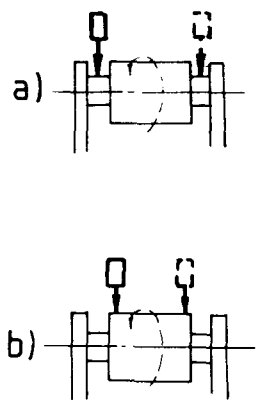
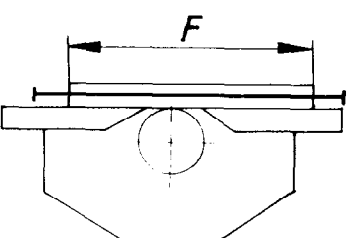


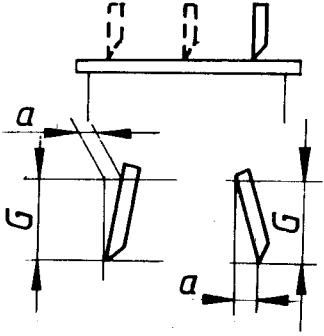
Reference	English Surface planing machines with cutterblock for one-side dressing
1	Framework
1.1	Main frame
2	Feed of workpiece and/or tools
3	Workpiece support clamp and guide
3.1	Infeed table
3.2	Outfeed table
3.3	Table lip plates
3.4	Canting fence
4	Tool-holders and tools
4.1	Blade
4.2	Cutterblock wedge
4.3	Cutterblock
5	Workheads and tool drives
5.1	Bearing
6	Controls
6.1	Starting switch
6.2	Infeed table vertical adjustment
6.3	Outfeed table vertical adjustment
6.4	Fence canting adjustment
6.5	Fence canting lock
6.6	Fence traverse lock
6.7	Infeed table adjustment scale
7	Safety devices
7.1	Cutterblock guard (bridge type)
7.2	Cutterblock rear guard
8	Miscellaneous
8.1	Dust extraction hood
8.2	Access door to control gear
9	(clause free)
10	Examples of work
10.1	Planing

5 Acceptance conditions and permissible deviations — Geometrical tests

No	Diagram	Object	Permissible deviations	Measuring instruments	Observations and references in ISO 230/1 test code
G1		Checking of flatness of the tables: a) longitudinal straightness b) diagonal straightness c) transverse straightness	a) and b) 0,10 for $A \leq 630$ 0,20 for $630 < A \leq 1\,250$ 0,30 for $A > 1\,250$ c) 0,10 for $B \leq 400$ 0,15 for $B > 400$	Straightedge and feeler gauge	Clauses 5.212 and 5.322
G2		Checking of parallelism of the two tables longitudinally	$C = 5$ 0,10 for $D \leq 1\,250$ 0,25 for $1\,250 < D \leq 2\,500$ 0,40 for $D > 2\,500$	Straightedge, slip gauges and feeler gauges	Flat to convex.

No.	Diagram	Object	Permissible deviations	Measuring instruments	Observations and references in ISO 230/1 test code
G3		Checking of parallelism of the lips of the tables transversely	$E = 5$ 0,10	Dial gauge	Clause 5.412.2
G4		Checking of parallelism of the cutterblock to the rear table	0,10 where the blade setting device is not carried from the cutterblock 0,05 where the blade setting device is carried from the cutterblock	Dial gauge	Clause 5.412.4

No.	Diagram	Object	Permissible deviations	Measuring instruments	Observations and references in ISO 230/1 test code
G5		Measuring of run-out of the cutterblock	0,03	Dial gauge	<p>Clause 5.612.2</p> <p>a) Where the blade setting device is carried from the block shoulders, check on the shoulders.</p> <p>b) Where the blade setting device is carried from the cutterblock check on the block.</p>
G6		Checking of straightness of the canting fence	<p>0,30 for $F \leq 800$</p> <p>0,40 for $F > 800$</p>	Straightedge and feeler gauges	Clause 5.212

No.	Diagram	Object	Permissible deviations	Measuring instruments	Observations and references in ISO 230/1 test code
G7		Checking of squareness of the canting fence to the tables	$\frac{a}{G}$ 0.10/100	Square and feeler gauges	

Annex

Equivalent terms

Reference	German	Spanish	Italian	Swedish
	Abbrichtobelmaschine	Cepilladora	Pialla a filo	Rikthyvel
1	Ständer	Armazón	Incastellatura	Stativkonstruktion
1.1	Gestell	Bastidor	Basamento	Stativ
2	Vorschub von Werkstück und/oder Werkzeug	Desplazamiento de las piezas y/o de los útiles	Spostamento dei pezzi e/o degli utensili	Matning av arbetsstycke och/eller verktyg
3	Werkstückauflage, -halterung und -führung	Soporte, sujeción y guía de las piezas	Supporto, fissaggio e guida dei pezzi	Styrning av arbetsstycke
3.1	Aufgabetisch	Mesa de entrada	Piano di entrata	Inmatningsbord
3.2	Abnahmetisch	Mesa de salida	Piano di uscita	Utmatningsbord
3.3	Tischlippen	Bocas de las mesas	Bordi dei piani	Bordläpper
3.4	Schrägstellbarer Fügeanschlag	Guía inclinable	Guida inclinabile	Snedställbart anhåll
4	Werkzeugträger und Werkzeug	Porta-útil y útiles	Portautensili ed utensili	Verktygshållare och verktyg
4.1	Streifenhobelmesser	Cuchillas	Coltelli	Kutterstål
4.2	Messerkeilleiste	Cuñas de bloqueo de las cuchillas	Lardoni conici di bloccaggio dei coltelli	Kil för fasthållning av kutterstål
4.3	Hobelmesserwelle	Árbol porta-útil	Albero portacoltelli	Kutterblock
5	Einbauteile und Teile für den Werkzeugantrieb	Unidad de trabajo y su transmisión	Unità operatrice e suo azionamento	Bearbetningsenheter och drivsystem
5.1	Hobelmesserwellenlager	Soporte del rodamiento	Supporto dei cuscinetti	Kutterlager
6	Bedienungs- und Überwachungsorgane	Mandos	Comandi	Manöverorgan
6.1	Elektrischer Schalter	Conmutador	Interruttore	Startdon
6.2	Höhenverstellung des Aufgabetisches	Mando de elevación de la mesa de entrada	Comando regolazione verticale del piano di entrata	Höjdinställning av inmatningsbordet
6.3	Höhenverstellung des Abnahmetisches	Mando de elevación de la mesa de salida	Comando regolazione verticale del piano di uscita	Höjdinställning av utmatningsbordet
6.4	Einstellung der Fügeanschlagneigung	Mando de la inclinación de la guía	Comando dell'inclinazione della guida	Inställning av anhåll
6.5	Blockierung der Fügeanschlagneigung	Mando de bloqueo de la inclinación de la guía	Comando bloccaggio dell'inclinazione della guida	Låsning av vinkelinställning av anhåll
6.6	Blockierung der Fügeanschlagverstellung	Mando de bloqueo del desplazamiento de la guía	Comando bloccaggio dello spostamento della guida	Låsning av anhållets läge
6.7	Höhenanzeige des Aufgabetisches	Reglaje milimétrico de la guía	Graduazione della regolazione verticale del piano di entrata	Fininställning av anhåll
7	Sicherheitseinrichtungen	Dispositivos de seguridad	Dispositivi di sicurezza	Säkerhetsanordningar
7.1	Vordere Messerwellenabdeckung	Protector del porta-útil	Protezione dell'albero portacoltelli	Kutterskydd framför anhåll
7.2	Hintere Messerwellenabdeckung	Protector posterior del porta-útil	Protezione posteriore dell'albero portacoltelli	Kutterskydd bakom anhåll
8	Verschiedenes	Diversos	Varie	Diverse
8.1	Absaugstutzen	Boca de aspiración	Presa per impianto aspirazione trucioli	Stos för spånugsug
8.2	Türe für die Maschinenwartung	Puerta de acceso a los mecanismos	Sportello d'ispezione agli organi meccanici	Inspektionsslucka
9				
10	Arbeitsbeispiele	Ejemplos de trabajo	Esempi di lavorazione	Bearbetningsexempel
10.1	Abbrichten	Cepillar	Piallatura	Rikthvyling

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